



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

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D350-636-016
Job Sheet 197909



Part No: D350-636-016

Job Qty: 1 pcs

Part Name: Skidtubes RH, Run-on Landing Wearplates, DART(Apical) Cylind./Aerazur Float Comp.



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/18/19

Job Tracking No:

Due Date: 8/8/19

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: DWG D4168-042 REV.C IPP rev:A 10.09.28 new issue DD ver:EC IPP Rev:B 11.04.14 ecn11-553 DD ver:EC IPP Rev:C 11.10.18 as per NCR 11-906 DD ver:EC IPP REV:D 13.08.28 PER ECN13-594 DD VERF:JLM IPP REV:E 18.11.12 AS PER DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - 1	1 pcs	8/8/19		0.00	4.78	Skidtubes - 1		DO
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
120	QC 10	1 pcs	8/8/19		0.00	0.00	QC 10 - 10		AUG 08 2019 DAS 50 9-89
							QC 10 - 18		
							QC 10 - 24		
							QC 10 - 43		
							QC 10 - 50		
							QC 10 - 58		
							QC 10 - 9		
130	QC 5	1 pcs	8/8/19		0.00	0.00	QC 5 - 10		AUG 08 2019 DAS 68 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		



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Container No: S199768



Part: D350-636-016

Job No: 197909

Serial No/Batch: S199768

Revision: C

Inspector:

Exp Date:

Instructions: FAA STC SR00646SE 18/10/17, TAA STC SH

Plex 7/18/19 10:44 AM Dart.lajeunesse.marie

				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
140 Handfinish - 1-1 Chemical-B4B	1 pcs	8/8/19	0.00 0.98	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	★ AUG 09 2019
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150 QC 7	1 pcs	8/8/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	BE
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	
160 Skidtubes - 2 - B4B	1 pcs	8/8/19	0.00 4.78	Skidtubes - 1 - B4B	TF
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	

170 QC 10	1 pcs	8/8/19	0.00 0.00	Skidtubes - 5 - B4B	BE
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
				QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	
180 QC 5	1 pcs	8/8/19	0.00 0.00	QC 10 - 50	DAS 50 9-89
				QC 10 - 58	
				QC 10 - 9	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
190 Handfinish - 2-1 Pressure- B4B	1 pcs	8/8/19	0.00 0.33	QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
200 Spray Paint - 2 - B4B	1 pcs	8/8/19	0.00 0.61	QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	E
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
210 QC 14	1 pcs	8/8/19	0.00 0.00	QC 5 - 81	
				Handfinish - 2 - 1 - B4B	
				Handfinish - 2 - 2 - B4B	SEP 10 2019
				Handfinish - 2 - 3 - B4B	
				Handfinish - 2 - 4 - B4B	
				Spray Paint - 1 - B4B	
				Spray Paint - 2 - B4B	RD 9-9-11
220 Packaging 2-1 - Receive - B4B	1 pcs	8/8/19	0.00 0.00	Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
				QC 14 - 15	M 19-9-12
				QC 14 - 2	
				QC 14 - 34	
				QC 14 - 41	
				QC 14 - 51	
				QC 14 - 58	
				QC 14 - 59	
				QC 14 - 9	
				QC 14 - 68	
				QC 14 - 40	
				QC 14 - 19	
				QC 14 - 43	
				QC 14 - 24	
				QC 14 - 61	
				QC 14 - 81	
				Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	

				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
230 Handfinish - 4-1-Assembly-B4B	1 pcs	8/8/19	0.00 0.98	Handfinish - 4 - 1 - B4B	1114-9-12
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
240 QC 5	1 pcs	8/8/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	

9/23/2019

					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
275	DC - 1 - B4B	1	8/8/19	0.00 0.00	DC - 1 - B4B	
		pcs			DC - 2 - B4B	SEP 26 2019
280	QC 21 - FG	1	8/8/19	0.00 0.00	QC 21 - FG - 21	DAS
		pcs			QC 21 - FG - 70	70
					QC 21 - SA - 53	9-89

Part Op 110 - (Skid tubes) 1- Pick D2600-3 Bent 2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT

Descriptions: end per dwg D4168-2 3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill then ream holes using 0.500" reamer. PIN first side. Repeat process on second side. ***ENSURE PROPER POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE*** Drill pilot holes as per Dwg D4168 sheet 5 (D4168-2 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail K) 4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting, section R-R and open to 0.500" 5- Drill tow ring hole using DT9616 detail "J" 6- Drill most FWD wearplate hole using DT9678 locating of 66.54" hole 7- Open up holes of Detail J to 0.297" (total of 2 holes per side) + .201" (total of one hole per side DT9616) as per dwg D4168. 8- Weld D2744 Cap as per Dwg D4168 and QSI 004. Fill grooves in bend left from bending as per QSI 004 A/R Aluminum Rod batch: 139011 9- Grind welds flush as per Dwg D4168

120 - (QC10- Inspect visual per QSI004- ground welds)

130 - (QC5- Inspect part completeness to step on W/O)

140 - (Chemical Conversion Coat per QSI005 4.1)

150 - (QC7-Inspect Chemical Conversion Coat)

160 - (Skid tubes) 1-Open up holes using hole saw of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D4168. 2-Open up holes using hole saw of Detail K to 0.750" (total of 4 holes per side) as per dwg D4168. 3- Open float hole to 0.500" using uni-bit (4 per side) and Run on wearplate holes to .375" 4 per side 4-Chamfer holes of Detail K,L, ground handling and float holes per dwg D4168 (welding instructions on sheet 9) 5-Deburr and blow out all chips from inside of tube 6- Prepare tube for welding, remove alodine as required. 7-Bond web D2739 in place as per QSI 015, let cure for 12hrs. A/R Sikaflex-291 batch: 5174342 exp. date: 12-08-2017 **ATTN: USE I-BEAM LOCATION AID (BLADE FITTING)*** 8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D4168 & QSI004 (welding instructions on sheet 8) A/R Aluminum Rod batch: 139011 9- At section AP-AP drill out x-bolt spacer to 0.404" 10- Grind welds flush as per Dwg D4168 11-Spot face ground handling holes section (total of 4 places per side) as per dwg D4168 12- C'bore section CH-CH. ADJUST TOOLING AS REQUIRED. VERF BY: _____ 13- Deburr holes, ensure tube is free of all scratches before sending to paint. ***** FOR DELUXE SKIDTUBE IF APPLICABLE DRILL TOW RING HOLE IN TUBE ***** REF TO W/O BATCH:

170 - (QC10- Inspect visual per QSI004- ground welds)

180 - (QC5- Inspect part completeness to step on W/O) ***VERIFY C'BOARD IS GOOD***

190 - HandFinish2 (Pressure Wash per QSI005 4.3/ Clean and remove all markings) Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

200 - (Spray Paint / NDT Room) 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: 5 2002099 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: 5 204428

210 - (QC14- Inspect Spray Paint) Inspect for foreign object per QSI 024

220 - Receive and inspect for damage + mat'l certs

230 - (Assemble as per dwg) 1- Install inserts as per Dwg D4168 2-Inspect for Foreign Objects 3-Install blade fitting D3488-4, wearshoes and ground handling hardware as per dwg D4168 Sika FLEX 241 BATCH: 5204025 EXP DATE: 2019-08-26 4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: M136247 5-Coat all exposed fasteners with "LPS Procyon" batch: M132691

240 - (QC5- Inspect part completeness to step on W/O)

250 - (Pick Kit) If making a D350-636-216 pick kit will only requires: 1 X AN3C37A 1 X AN3C34A 1 X AN3C42A 2 X D3493-1

260 - (QC4- 100% Inspect kits for completeness) *****ensure antiseize is on AN8C21A bolts*****

270 - Identify and pack for shipping as per PPPD350-636-016 Location : FG071

275 - (Document Control) record fwd angle: 84.7 Photocopy blue file and type labels per PPP D350-636-016 CHG 006

280 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2600-3-BENT-RH	Extrusion Bent RH	1 pcs (1 ea)	110-Skidtubes - 1	011 862
D2744	Cap	1 pcs (1 ea)	110-Skidtubes - 1	5197882
D2739	350 I-Beam	1 pcs (1 ea)	160-Skidtubes - 2 - B4B	5192776
D2743	Crossbolt Spacer	8 pcs (8 ea)	160-Skidtubes - 2 - B4B	5204179
D3490-1	Cross Bolt Spacer	4 pcs (4 ea)	160-Skidtubes - 2 - B4B	5194932
D3490-3	Cross Bolt Spacer	4 pcs (4 ea)	160-Skidtubes - 2 - B4B	5186298
ALS4-1032-225	Rivnut	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5199622
AN3C34A	Bolt	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5174369
AN3C36A	Bolt	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5186091-1
AN3C6A	Bolt	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	FN1132009-2
AN6C44A	Bolt	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5167183
AN8C35A	Bolt	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5160263
D2745	Bushing	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5167090
D3488-4	Blade Fitting, RH	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5206356
D3492-1	Plug	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5184402
D3492-3	Plug	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5202135
D3631-1	Washer	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5180192
D3873-1	Bushing	7 pcs (7 ea)	230-Handfinish - 4-1-Assembly-B4B	5209430
D4154-041	Wearplate Assembly	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5191509
D4170-1	Bushing	4 pcs (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5180748
D4171-1	Bushing	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5175928
MS21043-3	Nut	5 Ea (5 ea)	230-Handfinish - 4-1-Assembly-B4B	5099569
MS21043-6	Nut	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5166960
MS21083C8	Nut	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5167203-1
NAS1149C0332R	Washer (AN960C10L)	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5193136
NAS1149C0363R	Washer (AN960C10)	9 Ea (9 ea)	230-Handfinish - 4-1-Assembly-B4B	5135100
NAS1149C0832R	Washer (AN960C816L)	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5076017-2
NAS1515H3L	Washer	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5083529
NAS1611-010	O-Ring	8 Ea (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5057659
NAS1611-013	O-Ring	8 Ea (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5170279
AN3C37A	Bolt	1 Ea (1 ea)	250-Packaging 1-1 - Pick Kit - B4B	5168418
AN3C42A	Bolt	1 Ea (1 ea)	250-Packaging 1-1 - Pick Kit - B4B	5108570
AN8C21A	Bolt	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5184464
D2741	Replacement Blade	1 pcs (1 ea)	250-Packaging 1-1 - Pick Kit - B4B	5197663
D3493-1	Washer	2 pcs (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5199486
MS21083C8	Nut	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5215806
NAS1149D0863J	Washer	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5166718

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D2600-3-BENT-RH	1	7	0
	D2744	1	48	0
160-Skidtubes - 2 - B4B	D2739	1	12	0
	D2743	8	255	0
	D3490-1	4	153	0
	D3490-3	4	46	0
230-Handfinish - 4-1-Assembly-B4B	ALS4-1032-225	4	835	0
	AN3C34A	1	40	0
	AN3C36A	4	255	0
	AN3C6A	4	149	0
	AN6C44A	4	122	0
	AN8C35A	1	30	0
	D2745	8	64	0
	D3488-4	1	13	0
	D3492-1	8	67	0
	D3492-3	8	23	0
	D3631-1	8	376	0
	D3873-1	7	42	0
	D4154-041	1	12	0
	D4170-1	4	49	0
	D4171-1	1	26	0
	MS21043-3	5	934	0
	MS21043-6	4	99	0
	MS21083C8	1	93	0
	NAS1149C0332R	4	4,430	0
	NAS1149C0363R	9	695	0
	NAS1149C0832R	1	294	0
	NAS1515H3L	4	181	0
	NAS1611-010	8	219	0
	NAS1611-013	8	116	0
250-Packaging 1-1 - Pick Kit - B4B	AN3C37A	1	119	0
	AN3C42A	1	49	0
	AN8C21A	2	121	0
	D2741	1	56	0
	D3493-1	2	17	0
	MS21083C8	2	93	0
	NAS1149D0863J	2	375	0

Part Specifications

Specifications could not be found.

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Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D2600-3-BENT-RH	1	7	0
	D2744	1	48	0
160-Skidtubes - 2 - B4B	D2739	1	12	0
	D2743	8	255	0
	D3490-1	4	153	0
	D3490-3	4	46	0
230-Handfinish - 4-1-Assembly-B4B	ALS4-1032-225	4	835	0
	AN3C34A	1	40	0
	AN3C36A	4	255	0
	AN3C6A	4	149	0
	AN6C44A	4	122	0
	AN8C35A	1	30	0
	D2745	8	64	0
	D3488-4	1	13	0
	D3492-1	8	67	0
	D3492-3	8	23	0
	D3631-1	8	376	0
	D3873-1	7	42	0
	D4154-041	1	12	0
	D4170-1	4	49	0
	D4171-1	1	26	0
	MS21043-3	5	934	0
	MS21043-6	4	99	0
	MS21083C8	1	93	0
	NAS1149C0332R	4	4,430	0
	NAS1149C0363R	9	695	0
	NAS1149C0832R	1	294	0
	NAS1515H3L	4	181	0
	NAS1611-010	8	219	0
	NAS1611-013	8	116	0
250-Packaging 1-1 - Pick Kit - B4B	AN3C37A	1	119	0
	AN3C42A	1	49	0
	AN8C21A	2	121	0
	D2741	1	56	0
	D3493-1	2	17	0
	MS21083C8	2	93	0
	NAS1149D0863J	2	375	0
Part Specifications				
Specifications could not be found.				

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8 7 6 5 4 3 2 1

QTY -041	QTY -042	QTY -043	QTY -044	QTY -051	QTY -052	P/N	DESCRIPTION
X						D4188-041	350 SKIDTUBE ASSEMBLY, LH
	X					D4188-042	350 SKIDTUBE ASSEMBLY, RH
		X				D4188-043	350 SKIDTUBE ASSEMBLY, LH
			X			D4188-044	350 SKIDTUBE ASSEMBLY, RH
				X		D4188-051	350 SKIDTUBE ASSEMBLY, LH
					X	D4188-052	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	1	1	D2738	WEB
8	8	8	8	8	8	D2743	CROSS BOLT SPACER
1	1	1	1	1	1	D2744	CAP
8	8	8	8	8	8	D2745	BUSHING
1	1	1	1	1	1	D3489-3	BLADE FITTING, LH
4	4	4	4	4	4	D4080-1	BLADE FITTING, RH
4	4	4	4	4	4	D480-3	CROSS BOLT SPACER
8	8	8	8	8	8	D480-5	CROSS BOLT SPACER
8	8	8	8	8	8	D482-041	PLUG ASSEMBLY
8	8	8	8	8	8	D482-043	PLUG ASSEMBLY
8	8	8	8	8	8	D482-045	PLUG ASSEMBLY
8	8	8	8	8	8	D9301-1	WASHER
7	7	7	7	7	7	D973-1	BUSHING
1	1	1	1	1	1	D4154-041	WEARPLATE ASSEMBLY
1	1	1	1	1	1	D4188-1	SKIDTUBE WELDMENT, LH
1	1	1	1	1	1	D4188-2	SKIDTUBE WELDMENT, RH
1	1	1	1	1	1	D4188-3	SKIDTUBE WELDMENT, LH
1	1	1	1	1	1	D4188-4	SKIDTUBE WELDMENT, RH
1	1	1	1	1	1	D4188-5	SKIDTUBE WELDMENT, LH
4	4	4	4	4	4	D4170-1	SKIDTUBE WELDMENT, RH
1	1	1	1	1	1	D4171-1	SPACER
1	1	1	1	1	1	D4171-1	BUSHING
4	4	4	4	4	4	AL84-1022-225	INSERT
1	1	1	1	1	1	AN3C34A	BOLT
4	4	4	4	4	4	AN3C38A	BOLT
4	4	4	4	4	4	AN3C3A	BOLT
4	4	4	4	4	4	AN3C4A	BOLT
1	1	1	1	1	1	AN3C35A	BOLT
5	5	5	5	5	5	MS21043-3	NUT
4	4	4	4	4	4	MS21043-5	NUT
1	1	1	1	1	1	MS21053C3	NUT
4	4	4	4	4	4	NAS1146C0332R	WASHER
9	9	9	9	9	9	NAS1146C0363R	WASHER
1	1	1	1	1	1	NAS1146C0363R	WASHER
4	4	4	4	4	4	NAS1515P3L	WASHER

NOTES:

- 1) MATERIAL: MAKE D4188-1/2-3/4-5/8 FROM D2800-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1 PRIOR TO INSTALLING D2738 WEB. STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005.4.3. OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005.4.3. BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005.4.4 (OPTIONAL).

- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

- 4) UNITS: INCHES UNLESS OTHERWISE NOTED

- 5) BREAK SHARP EDGES: N/A

- 6) IDENTIFICATION: N/A

- 7) WEIGHT: D4188-041/042/043/044 = 32.3 lbs

- 8) WELD PER DART QSI 004

- 9) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:

- 10) MINIMUM YIELD TENSILE STRENGTH = 36 KSI

- 11) MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI

- 12) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF FINISH WITH MEK DEGREASER.

- 13) SPACER AND PLUG INSTALLED SAME AS SECTION A-JAJ EXCEPT HORIZONTAL

- 14) SPACER AND PLUG INSTALLED SAME AS SECTION A-JAJ EXCEPT HORIZONTAL

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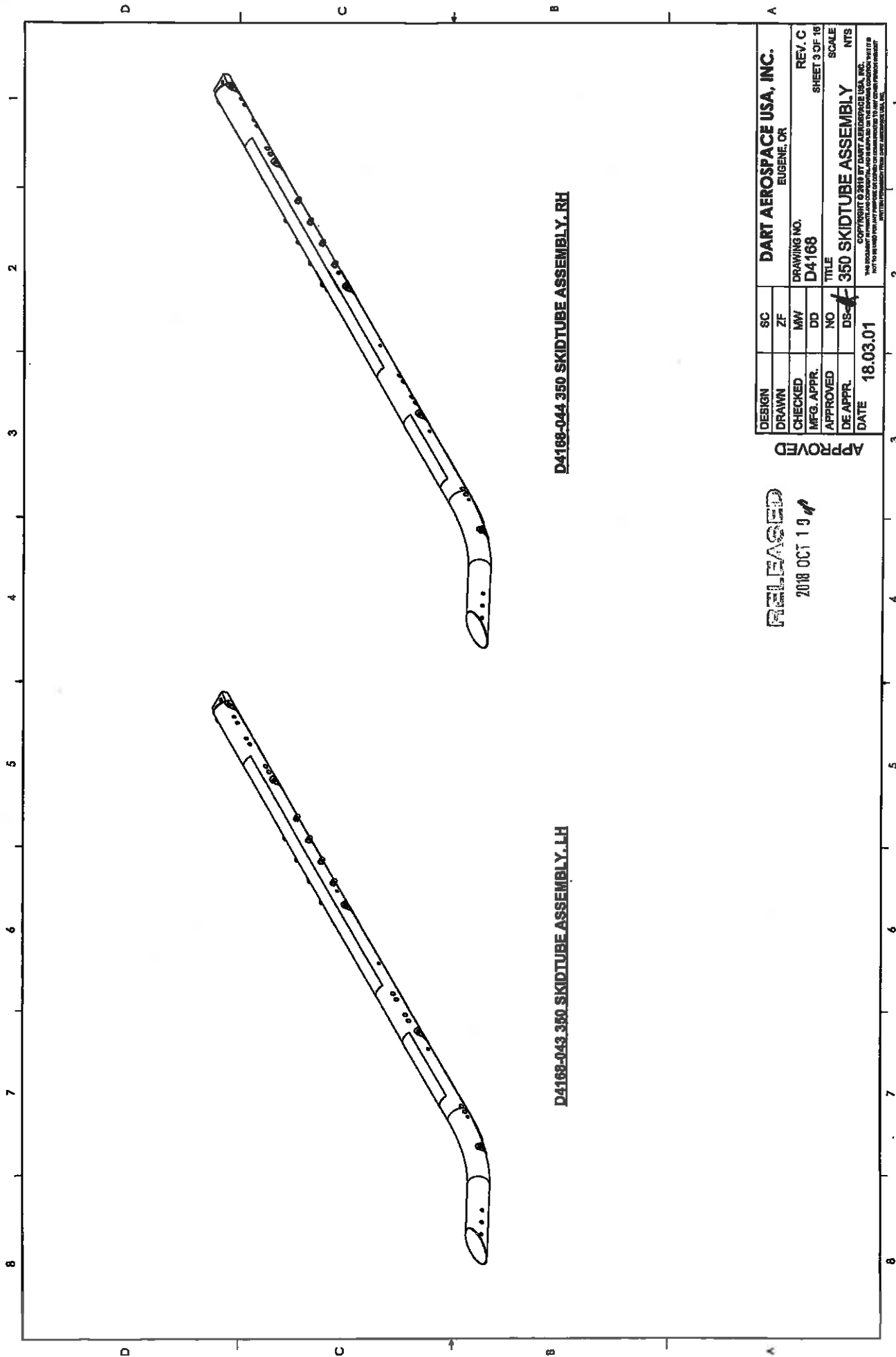
WITHOUT NOTICE

WORK ORDER

NO. 199909 MVS

19-07-18

C	ADDED: 05/14/88 (ZN C1-1, C1-2, C1-3, C1-4, C1-5, C1-6, C1-7, C1-8, C1-9, C1-10, C1-11, C1-12, C1-13, C1-14, C1-15, C1-16, C1-17, C1-18, C1-19, C1-20, C1-21, C1-22, C1-23, C1-24, C1-25, C1-26, C1-27, C1-28, C1-29, C1-30, C1-31, C1-32, C1-33, C1-34, C1-35, C1-36, C1-37, C1-38, C1-39, C1-40, C1-41, C1-42, C1-43, C1-44, C1-45, C1-46, C1-47, C1-48, C1-49, C1-50, C1-51, C1-52, C1-53, C1-54, C1-55, C1-56, C1-57, C1-58, C1-59, C1-60, C1-61, C1-62, C1-63, C1-64, C1-65, C1-66, C1-67, C1-68, C1-69, C1-70, C1-71, C1-72, C1-73, C1-74, C1-75, C1-76, C1-77, C1-78, C1-79, C1-80, C1-81, C1-82, C1-83, C1-84, C1-85, C1-86, C1-87, C1-88, C1-89, C1-90, C1-91, C1-92, C1-93, C1-94, C1-95, C1-96, C1-97, C1-98, C1-99, C1-100, C1-101, C1-102, C1-103, C1-104, C1-105, C1-106, C1-107, C1-108, C1-109, C1-110, C1-111, C1-112, C1-113, C1-114, C1-115, C1-116, C1-117, C1-118, C1-119, C1-120, C1-121, C1-122, C1-123, C1-124, C1-125, C1-126, C1-127, C1-128, C1-129, C1-130, C1-131, C1-132, C1-133, C1-134, C1-135, 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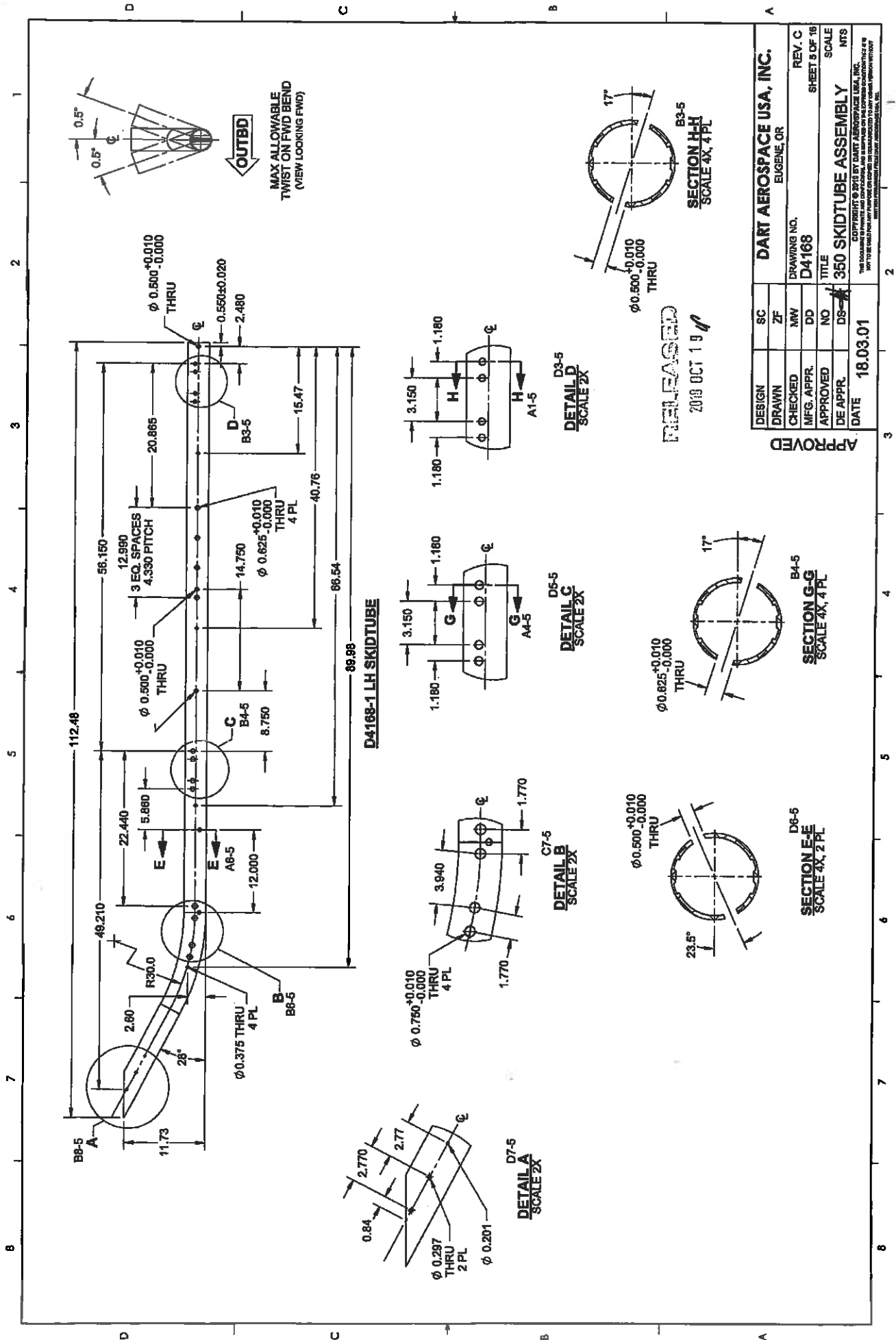
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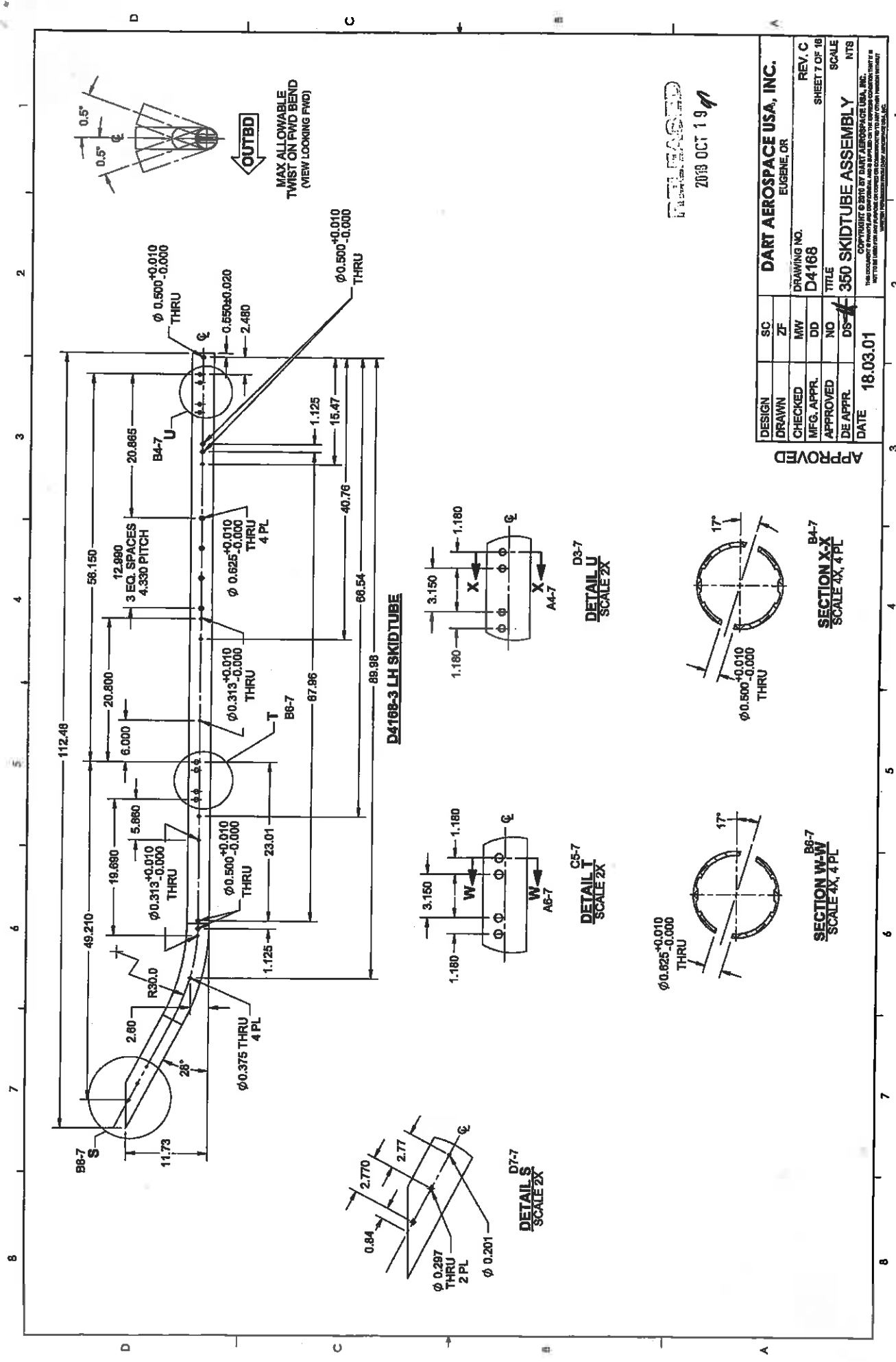
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DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
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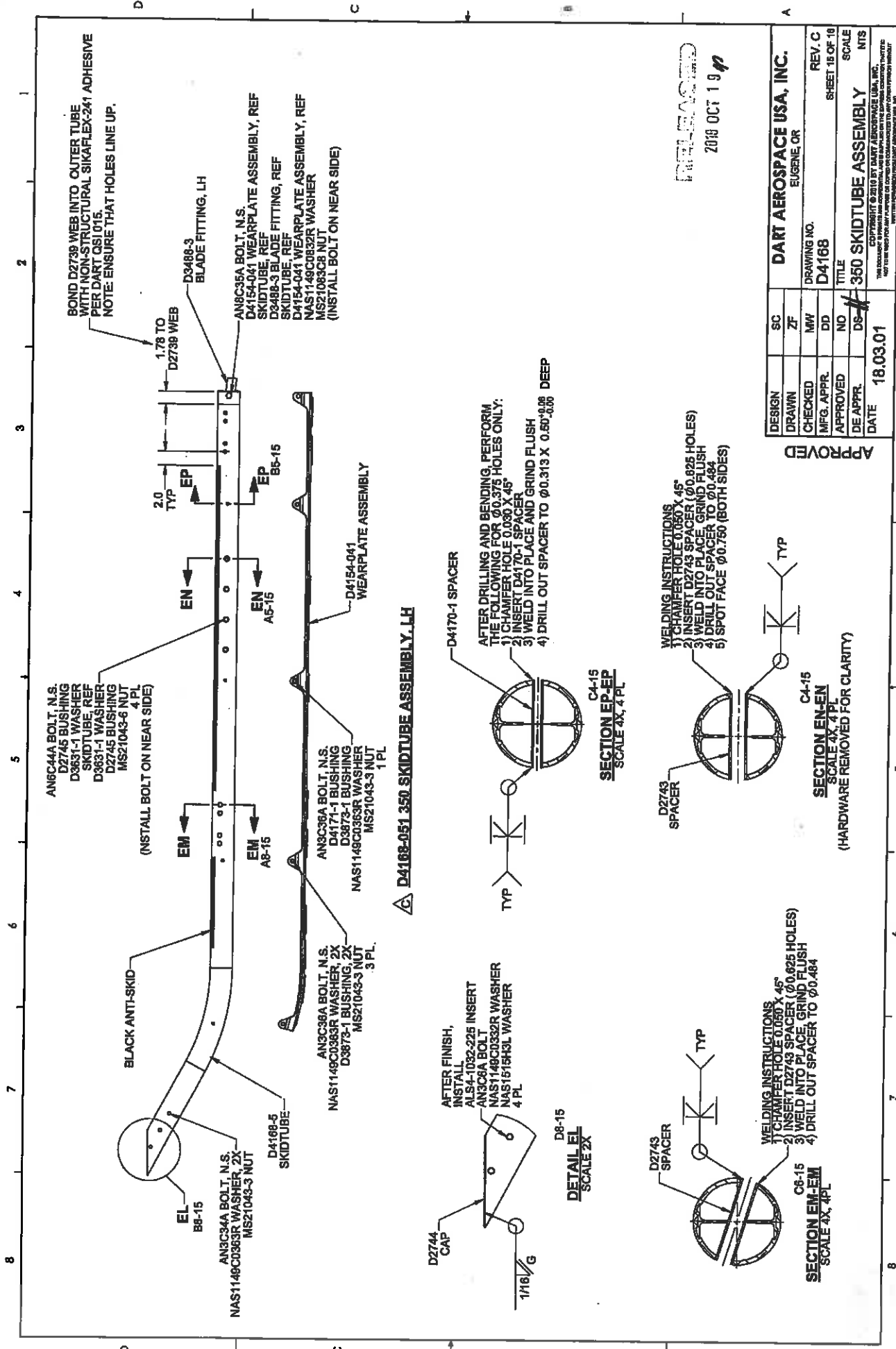
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DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	ZF	EUGENE, OR	
CHECKED	MY	DRAWING NO.	REV. C
MFG. APPR.	DD	D4168	SHEET 7 OF 18
DE APPR.	NO	TITLE	SCALE
DATE	18.03.01	350 SKIDTUBE ASSEMBLY	NTS

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D4168-051 350 SKIDTUBE ASSEMBLY, LH

RELEASED
2019 OCT 19

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SHEET 15 OF 18			
SCALE			
TITLE			
350 SKIDTUBE ASSEMBLY			
NTS			

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Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ Scrap ☐ ☐ Use-as-is ☐ ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐				Date : _____ Sequence #: _____		QTY Affected : _____ MRB (QS1042) _____	
Description Work Order Deviation				Disposition							
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐				Other/Details: _____							
Completed By				Lead hand / Supervisor							
QC / QA Coordinator				_____							

7.0 PARTS LIST

D350-636-015/-016/-017/-018 SKIDTUBES AT CHG 006 AND SUBSEQUENT
D350-636-023/-024 SKIDTUBES AT CHG 001 AND SUBSEQUENT

Item	Qty -015	Qty -016	Qty -017	Qty -018	Qty -023	Qty -024	Qty -047	Part Number	Description
	X							D350-636-015	SKIDTUBE INSTALLATION, LH, AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE W/TRAINING WEARPLATE
		X						D350-636-016	SKIDTUBE INSTALLATION, RH, AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE W/TRAINING WEARPLATE
			X					D350-636-017	SKIDTUBE INSTALLATION, LH AIRCRAUSER/DART TRI-BAG FLOAT COMPATIBLE W/TRAINING WEARPLATE
				X				D350-636-018	SKIDTUBE INSTALLATION, RH AIRCRAUSER/DART TRI-BAG FLOAT COMPATIBLE W/TRAINING WEARPLATE
					X			D350-636-023	SKIDTUBE INSTALLATION, LH, STD COMPATIBLE W/TRAINING WEARPLATE
						X		D350-636-024	SKIDTUBE INSTALLATION, RH, STD COMPATIBLE W/TRAINING WEARPLATE
							X	D350-636-047	TRAINING WEARPLATE KIT (LH/RH)
1	1							D4168-041	SKIDTUBE ASSEMBLY, LH
1		1						D4168-042	SKIDTUBE ASSEMBLY, RH
1			1					D4168-043	SKIDTUBE ASSEMBLY, LH
1				1				D4168-044	SKIDTUBE ASSEMBLY, RH
1					1			D4168-051	SKIDTUBE ASSEMBLY, LH
1						1		D4168-052	SKIDTUBE ASSEMBLY, RH
*1	1							D4168-1	SKIDTUBE WELDMENT, LH
*1		1						D4168-2	SKIDTUBE WELDMENT, RH
*1			1					D4168-3	SKIDTUBE WELDMENT, LH
*1				1				D4168-4	SKIDTUBE WELDMENT, RH
*1					1			D4168-5	SKIDTUBE WELDMENT, LH
*1						1		D4168-6	SKIDTUBE WELDMENT, RH
**2	8	8	8	8	8	8		350A41-1027-20	SCREW
**3	8	8	8	8	8	8		23119AG120LE	WASHER
**4	8	8	8	8	8	8		22541N120	NUT
*5	1	1	1	1	1	1		AN8C35A	BOLT
*6A	1	1	1	1	1	1		NAS1149CO832R	WASHER
*7	1	1	1	1	1	1		MS21083C8	NUT
*8	1		1		1			D3488-3	BLADE FITTING, LH
*8		1		1		1		D3488-4	BLADE FITTING, RH
9	1	1	1	1	1	1		D2741	BLADE
10	2	2	2	2	2	2		AN8C21A	BOLT
11	2	2	2	2	2	2		NAS1149CO863J	WASHER
12	2	2	2	2	2	2		MS21083C8	NUT
*14	4	4	4	4	4	4		AN6C44A	BOLT
*15	8	8	8	8	8	8		D2745	BUSHING
*16	4	4	4	4	4	4		MS21043-6	NUT
*17	8	8	8	8	8	8		D3631-1	WASHER
*18	4	4	4	4	4	4		ALS4-1032-225	INSERT
*19	4	4	4	4	4	4		AN3C6A	BOLT
*20A	4	4	4	4	4	4		NAS1149CO332R	WASHER
*20B	4	4	4	4	4	4		NAS1515H3L	WASHER

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Revision: K

Date: 18.04.04

Item	Qty -015	Qty -016	Qty -017	Qty -018	Qty -023	Qty -024	Qty -047	Part Number	Description
*30	8	8	8	8				D3492-041	PLUG ASSEMBLY
*31	8	8						D3492-043	PLUG ASSEMBLY
*32			8	8				D3492-045	PLUG ASSEMBLY
***43	2	2	2	2				D3493-1	WASHER
*90	1	1	1	1	1	1	1	D4154-041	WEARPLATE ASSEMBLY
*91A	4	4	4	4	4	4	4	AN3C36A	BOLT ¹
91B	1	1	1	1	1	1	1	AN3C37A	BOLT ²
91C	1	1	1	1			1	AN3C42A	BOLT ³
*92	7	7	7	7	7	7	8	NAS1149CO363R	WASHER
92A			1	1				NAS1149CO363R	WASHER ³
*93	4	4	4	4	4	4	4	MS21043-3	NUT
*94	7	7	7	7	7	7	8	D3873-1	BUSHING
94A			1	1				D3873-1	BUSHING ³
*95	1	1	1	1	1	1	1	D4171-1	BUSHING ⁴
96							4	D4170-3	SPACER
*97	1	1	1	1	1	1	1	AN3C34A	BOLT
*98	2	2	2	2	2	2	2	NAS1149CO363R	WASHER
*99	1	1	1	1	1	1	1	MS21043-3	NUT

* PART OF D4168-041/-042/-043/-044/-051/-052

** TO BE SUPPLIED BY CUSTOMER

*** ONLY INSTALLED IF INSTALLING A DART FLOAT SYSTEM

¹ QTY USED MAY BE LESS ON SKIDTUBES WITH DART CYLINDRICAL OR TRI-BAG FLOATS

² HARDWARE USED ON THE SKIDTUBES INSTALLED WITH DART CYLINDRICAL BAG FLOATS

³ HARDWARE USED ON THE SKIDTUBES INSTALLED WITH DART TRI-BAG FLOATS

⁴ HARDWARE NOT USED ON THE SKIDTUBES INSTALLED WITH DART TRI-BAG FLOATS